

Date: Thursday, 08/05/2008 11:57:48 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	206L/L3/L4 HIGH GEAR SKID
Job Number :	39119	Part Number :	D206642412
Estimate Number :	10526	Drawing Number :	N/A
P.O. Number :		Project Number :	N/A
This Issue :	08/05/2008	Drawing Revision :	L
Prsht Rev. :	NC	Material :	
First Issue :	/ /	Due Date :	30/05/2008
Previous Run :	39118	Qty:	1 Um: Each
Written By :			
Checked & Approved By :	JLD 08.5.08		
Comment :	Est Rev:K 05.10.11 Revised picklist per CHG004 KJ/CP/JLM Est Rev:L 07-12-05 ECN 1080p DD verified by:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-412 CHG004

JLD
08.5.12

2.0	39119A	206 L HIGH GEAR SKIDTUBE
-----	--------	--------------------------

**Comment:** Sub-Component 206 L HIGH GEAR SKIDTUBE

D206-642-441 B 39119A SQ

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Pick Packing Kit

4.0	D206648011	GHW Modification
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GHW Modification Kit

Batch: 36140 SQ

5.0	D2652	Bushing
-----	-------	---------

**Comment:** Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

16 D2652

Bushing

38815

1 D206-642-441(REF)

39119A

5/5/26 SQ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 08/05/2008 11:57:48 AM
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Job Number: 39119

Part Number: D206642412

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D2655	Ring
-----	-------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2655

Tow Ring

34163

sq

7.0	D2712	Set Screw
-----	-------	-----------



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

10 D2712

Set Screw

341628

sq

8.0	D29322	Saddle RH Out, 206
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2932-2

Saddle

37865

sq

9.0	D29332	Saddle RH In, 206
-----	--------	-------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2933-2

Saddle

37423

sq

10.0	D2934	Saddle Spacer
------	-------	---------------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 D2934

Saddle Spacer

37368

sq

11.0	D2935	Saddle Spacer
------	-------	---------------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 D2935

Saddle Spacer

37867

8/5/06

sq

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 39119

Part Number: D206642412

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D29382

Saddle RH Out, 206



(H)

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2938-2

Saddle

1339737

8/6/13

50

13.0

D29392

Saddle RH In, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2939-2

Saddle

36/44

50

14.0

D2968043

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2968-043

Tow Ring

37380

50

15.0

AN341A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 AN3-41A

Bolt

107242

50

16.0

AN45A

Bolt



(H)

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 AN4-5A

Bolt

106605

8/5/26

50

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

AN46A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

12 AN4-6A

Bolt

106662

sd

18.0

AN513A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

batch

104936

sd

19.0

AN512A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 AN5-12A

Bolt

M104885

sd

20.0

AN511A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Bolt

batch

105870

sd

21.0

AN960JD10

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 AN960JD10

Washer

9221

8/5/26

sd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Part Number: D206642412

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

AN960JD1016

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Qty Part Number Description Batch

1 AN960JD1016 Washer 5519

SD

23.0

AN960JD416

Washer



Comment: Qty.: 25.0000 Each(s)/Unit Total: 25.0000 Each(s)

Qty Part Number Description Batch

25 AN960JD416 Washer 107321

SD

24.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Qty Part Number Description Batch

8 AN960JD516 Washer 107584

SD

25.0

AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Qty Part Number Description Batch

1 AN970-4 Washer 107715

SD

26.0

MS21042L3

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Qty Part Number Description Batch

8 MS21042L3 Nut (or -3) 19971

SD

27.0

MS21042L4

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total: 13.0000 Each(s)

Qty Part Number Description Batch

13 MS21042L4 Nut (or -4) 107472

8/5/26

SD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: 206L/L3/L4 HIGH GEAR SKID

Job Number: 39119

Part Number: D206642412

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Snatched c.k. 1 in box

08-06-13 ①

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-412

Location: *81*

PPP Rev: *C*

AS 08/06/13 ④
08/06/16

1x

30.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08.06.16

39119A

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.4 206L/L-1/L-3/L-4 High Gear Skidtubes

Item	Qty -411	Qty -412	Qty -441	Qty -443	Qty -011	Part Number	Description
	X					D206-642-411	SKIDTUBE INSTALLATION, LH
		X				D206-642-412	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-441	SKIDTUBE
				X		D206-642-443	WEARSHOE KIT
	1	1			X	D206-648-011	GROUND HANDLING KIT
1			1			D2650-7	SKIDTUBE ASSEMBLY
2A			22			D2651-1	* PLUG ⁽¹⁾
2B			22			D2651-3	* O-RING ⁽¹⁾
3			1			D2646	* AFT CAP ⁽¹⁾
4			2			MS27039-1-08	* SCREW ⁽¹⁾
5			2			AN960JD10L	* WASHER ⁽¹⁾
6	1					D2932-1	SADDLE, FWD OUT, LH
6		1				D2932-2	SADDLE, FWD OUT, RH
7	1					D2933-1	SADDLE, FWD IN, LH
7		1				D2933-2	SADDLE, FWD IN, RH
8	1					D2938-1	SADDLE, AFT OUT, LH
8		1				D2938-2	SADDLE, AFT OUT, RH
9	1					D2939-1	SADDLE, AFT IN, LH
9		1				D2939-2	SADDLE, AFT IN, RH
10	8	8				AN3-41A	BOLT
11	16	16				D2652	BUSHING
12A	8	8				MS21042-3	NUT (OR MS21042L3)
12B	8	8				AN960JD10	WASHER
13	4	4				AN5-11A (OR AN5-12A)	* BOLT ⁽²⁾
14	4	4				AN5-11A (OR AN5-13A)	* BOLT ⁽²⁾
15	8	8				AN960JD516	WASHER
16	12	12				AN4-6A	BOLT
17	24	24				AN960JD416	WASHER
18	12	12				MS21042-4	NUT (OR MS21042L4)
20A			6			D2648-3	WEARPAD
21A			1			D3429-1	WEARPAD
22A			1	1		D2656-15	WEARSHOE
23A			1	1		D2656-23	WEARSHOE
24A			1	1		D2656-37	WEARSHOE
26A			60			MS27039-1-08	SCREW
26B			60			AN960JD10L	WASHER
26C			60			ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1				D2707-043 (OR D2968-043)	TOW RING
31	1	1				AN960JD1016	WASHER
32	1	1				AN970-4	WASHER
33	1	1				MS21042-4	NUT (OR MS21042L4)
34	1	1				AN4-5A	BOLT
35	1	1				AN960JD416	WASHER
36	1	1				D2655	RING
37	10	10				D2712	SET SCREW
38	2	2				D2934	SADDLE SPACER
39	2	2				D2935	SADDLE SPACER
40					2	D2659	GHW LUG
41					4	AN3-37A	BOLT
42					8	D2652	BUSHING
43					4	MS21042-3	NUT (OR MS21042L3)
44					4	AN960DJ10	WASHER

NOTES: ⁽¹⁾ DENOTES THAT PART IS INCLUDED WITH D2650-7 ASSEMBLY ABOVE
⁽²⁾ CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39119

Date: Thursday, 08/05/2008 11:58:12 AM
User: Julia Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206 L HIGH GEAR SKIDTUBE
Job Number : 39119A
Estimate Number : 10522
P.O. Number : Part Number : D206642441
This Issue : 08/05/2008 S.O. No. : Drawing Number : D2650 REV E
Prsht Rev. : NC Project Number : N/A
First Issue : / / Type : SKIDTUBES Drawing Revision : E
Previous Run : 39118A Material :
Written By : Due Date : 30/05/2008 Qty: 1 Um: Each
Checked & Approved By : JLD 08.5.08
Comment : Est Rev: H 05.10.11 Added D3429-1 per CHG002 KJ/CP/JLM
Est Rev: I - 08-05-01- add QC3 - DD - verified by: EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-441 CHG002

N/A

2.0 D2620 Skidtube, 206 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2620 Bent Tube 3" OD 32449

25 08-05-12

3.0 D2647 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2647 Fwd Cap 235475

BE 08/05/12

4.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R Aluminum Rod m107263/m107877 BE 08/05/12

4-Grind weld flush to cap on top surface only. SL 8-5-13

} BT 08-05-12

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 39119A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

5-Cut aft end 138.60" from front of tube

6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312"

7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297"

8-Open using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtube as per Dwg D2650

11-Deburr and Blow out all chips from inside the tube

SL 8-5-13

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SL 8-5-13

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

D M 8-5-13

7.0

D26547

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2654-7

Web

35994

SL 8-5-13

8.0

SKIDTUBES 1

SKIDTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail (without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650 (without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-7 web in place as per QSI 015 Ensure holes line up Allow 12 Hrs. cure time before cutting

Start Date: 8-5-13 Time: 9:10

Finish Date: 8-5-14 Time: 10:00

8-5-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 39119A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

A/R Sikaflex-291

107804

Sikaflex expiry date:

8-7-31

9.0

QC5

INSPECT WORK TO CURRENT STEP



08/05/14 (EC)



Comment: INSPECT WORK TO CURRENT STEP

08/05/14

10.0

D2649

Cross Bolt Spacer



Comment: Qty.: 23.0000 Each(s)/Unit Total : 23.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

23 D2649

Crossbolt spacer

297859

BE 08/05/14

11.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

A/R Aluminum Rod

M107877

BE 08/05/14

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube

SL 8-5-15

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650Debur

SL 8-5-20

12.0

D2680041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2680-041

Nut Plate

34599

SL 8-5-20

13.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 CCR264SS3-3

Rivets

107707

SL 8-5-20

W/O:		WORK ORDER CHANGES					
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Process Sheet

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Part Number: D206642441



Description :

Rivet



Pick:

Description	Batch
Rivets	102615

HAND FINISHING RESOURCE #1

[illegible][illegible]

Install D2680-041 Nut Plate as per Dwg D2650

SL 88-20

VISUAL INSPECTION OF GROUND WELDS

[illegible]

006/20 (20)

INSPECT WORK TO CURRENT STEP

[illegible][illegible]

08/05/20 (x)

HAND FINISHING RESOURCE #1

[illegible][illegible]

Pressure wash as per QSI 005

Q13/138 08-05-20 0

POWDER COATING

[illegible]

(Signature)

Powder Coat White (Ref. 4.3.5.1) as per QSI 005 4.3
Make sure Nut Plate Thread protected use paint screw.

Q: 50 am

OVEN TEMPERATURE:

$$\frac{0}{320} \text{ } ^{\circ}\text{F}$$

FINISH TIME:

9:20 am

M. 08/05/20

INSPECT POWDER COAT/CHEMICAL CONVERSION

[illegible][illegible]

FL 08/05/21 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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User: Julie Lecoq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 39119A

Part Number: D206642441

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

21.0	D26483	Wearpad
------	--------	---------



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch
6 D2648-3 Wearpad D34591

FL

22.0	D265615	Wearshoe
------	---------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2656-15 Wearshoe D34596

FL

23.0	D265623	Wearshoe
------	---------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2656-23 Wearshoe D34597

FL

24.0	D265637	Wearshoe
------	---------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2656-37 Wearshoe D34510

FL

25.0	D34291	Wearpad
------	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3429-1 Wearpad D34609

FL

26.0	ALS41032130	Insert
------	-------------	--------



Comment: Qty.: 60.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number Description Batch
60 ALS4-1032-130 Inserts m105819

FL 08/05/21 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 08/05/2008 11:58:12 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 39119A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

or (see QSI 017)

27.0

AN960JD10L

Washer



Comment: Qty.: 62.0000 Each(s)/Unit Total: 62.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 AN960JD10L

Washer

m104885

FL

28.0

MS27039108

Screw



Comment: Qty.: 62.0000 Each(s)/Unit Total: 62.0000 Each(s)

Pick:

Qty Part Number

Description Batch

62 MS27039-1-08

Screw

m107378

FL

29.0

D26511

Plug



Comment: Qty.: 22.0000 Each(s)/Unit Total: 22.0000 Each(s)

Pick:

Qty Part Number

Description Batch

22 D2651-1

Plugs

D38273

FL

30.0

D26513

O-Ring



Comment: Qty.: 22.0000 Each(s)/Unit Total: 22.0000 Each(s)

Pick:

Qty Part Number

Description Batch

22 D2651-3

O-Rings

D36141

FL

31.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 AN960JD416

Washer

m105426

FL 08/05/21 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: .. Thursday, 08/05/2008 11:58:12 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 39119A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

MS27039406

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 MS27039-4-06

Screw

m106541

FL

33.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2646

Aft Cap

036184

FL

34.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R Sikaflex-291

Sikaflex expiry date:

m107804
08/10

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R Sikaflex-291

Sikaflex expiry date:

m107804
08/10

6-Wing Walk as per Dwg D2650-7 and QSI 005 4.4

Batch: m107892

217/m-h

08/05/22

(1X)

35.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/05/22 (40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 08/05/2008 11:58:12 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 39119A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

PACKAGING 1

PACKAGING RESOURCE #1



①

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPP 39119

8/6/13

SIP

37.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/16

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08/06/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2650	REV. E SHEET 1 OF 5
DATE 06.03.30		TITLE 206/407 SKIDTUBE ASSEMBLIES	SCALE NTS
A	97.03.25	NEW ISSUE	
B	97.06.26	AS MANUFACTURED CHANGES	
C	97.10.29	CHANGE HOLE PATTERN AND FRONT END	
D	04.05.17	REDRAW; INCORP. DE09136/9153/9163 MOD GROUND HNDLNG ON D2650-1/-3	
E	06.03.30	RMV C'BORE, CHG DRILL, ADD CHAMFER	

RELEASED
16 04 17 *[Signature]*

Qty -1	Qty -3	Qty -5	Qty -7	Part Number	Description
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
16	17	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

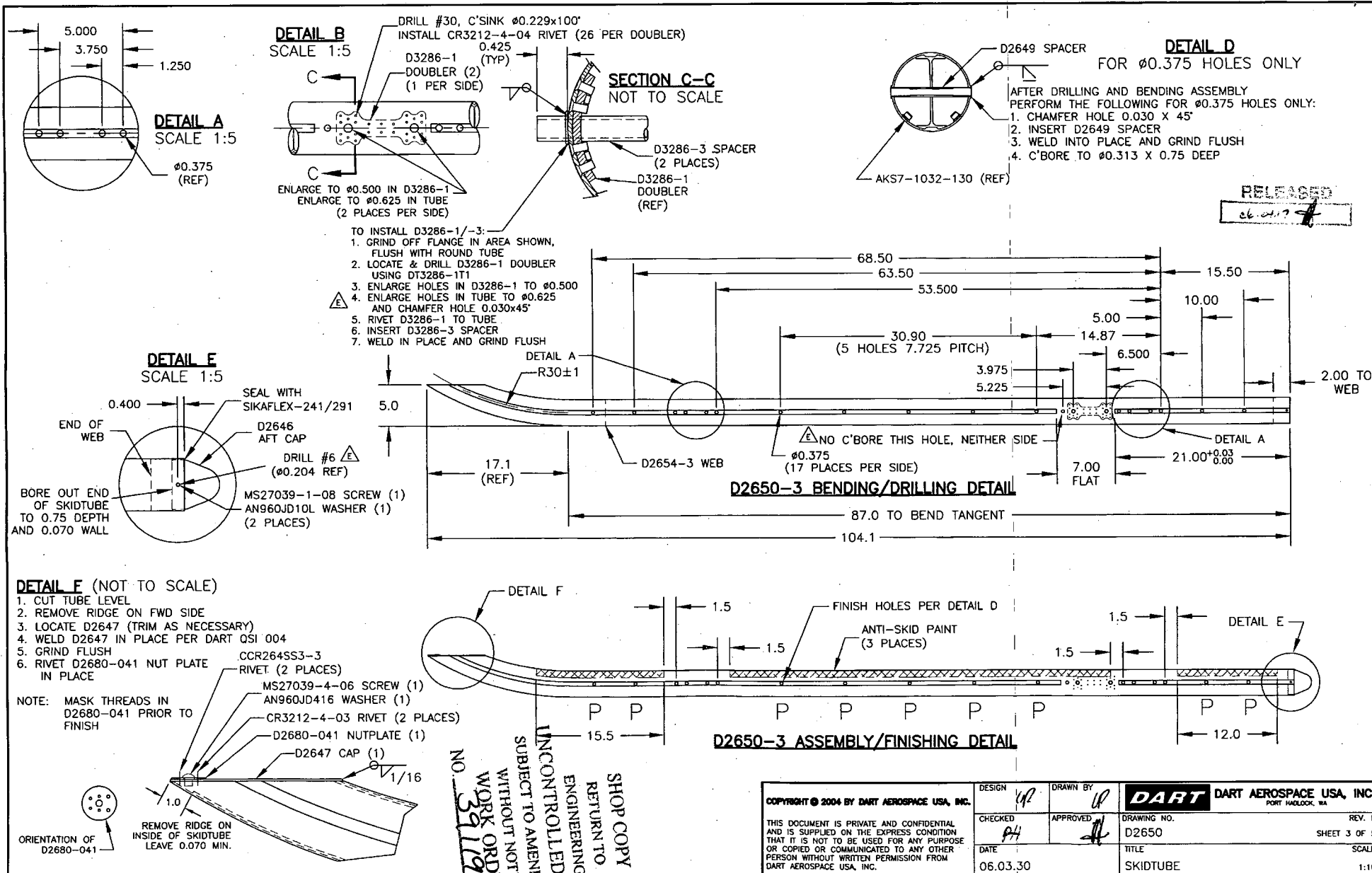
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WITHOUT NOTICE
WORK ORDER
NO. 39119A**NOTES**

- 1) WELD PER DART QSI 004
- 2) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 3) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 4) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 5) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 6) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

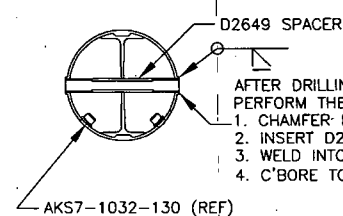
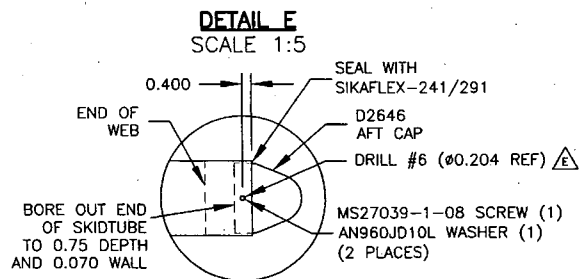
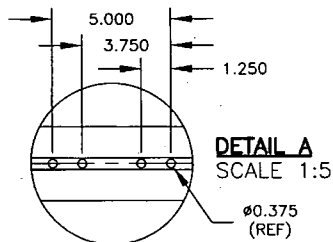
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DRAWING NO.	REV. 8
D2650	SHEET 2 OF 5
TITLE	SCALE
SKIDTUBE	1:10



15.5
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WORK ORDER
NO. 3911914

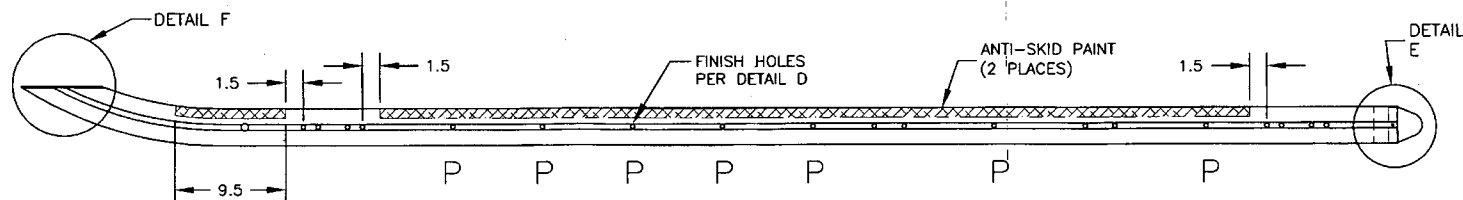
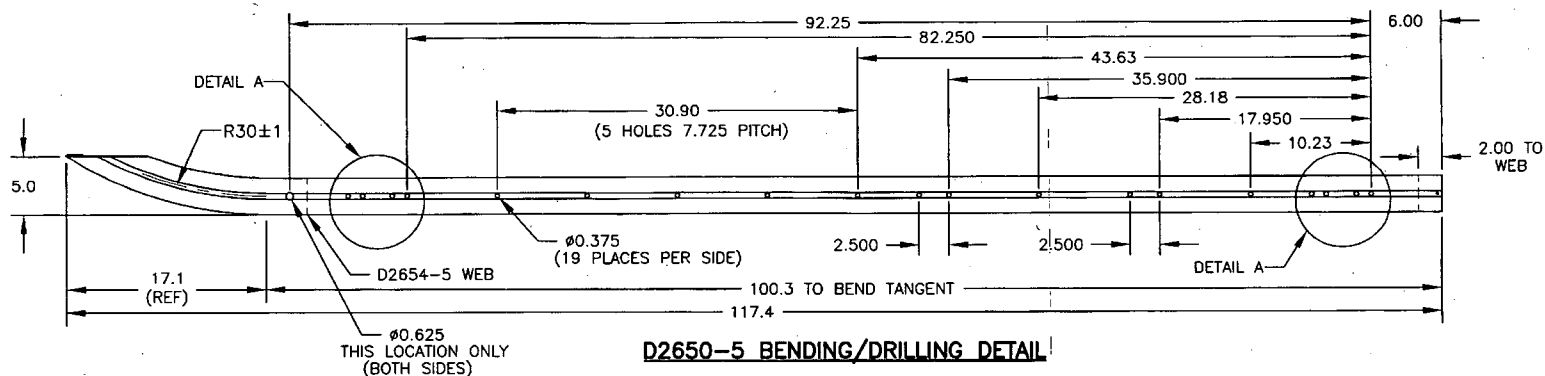


DETAIL D
FOR Ø0.375 HOLES ONLY

AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:

1. CHAMFER HOLE 0.030 X 45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE TO Ø0.313 X 0.75 DEEP

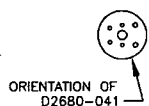
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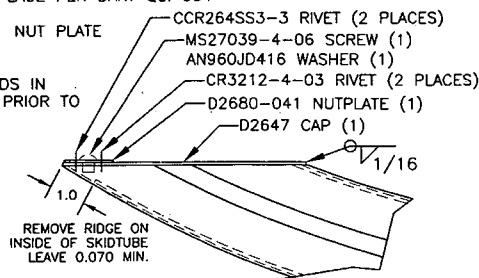
DETAIL F (NOT TO SCALE)

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH




REMOVE RIDGE ON INSIDE OF SKIDTUBE. LEAVE 0.070 MIN.



NO. 321127
WORK ORDER
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CHECKED	PH	APPROVED		DRAWING NO.	REV. E
DATE	06.03.30	TITLE	SKIDTUBE	SHEET 4 OF 5	SCALE
					1:10

 DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWING NO.	REV. E
D2650	SHEET 5 OF 5
TITLE	SCALE
SKIDTUBE	1:10

NO. 155

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 369629
Part number: D206 642 641
Description: 206 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:
Penetration:

pass[☒] fail[]
pass[☒] fail[]

UNACCEPTABLE

Cracks:
Undercut:
Pin holes:
Overlap (cold lap)
Porosity (surface):
Coloration:

pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]

Qualifier Pet Duval Date of Test Coupon 08-05-09
Welder Barclay Elliot Date of Test Coupon 08-05-09

The above named individual is qualified in accordance with AWS D17.1.2001 to weld